

**Work Order ID 79421****\*79421\***

Page 1

January-26-12 7:43:22 AM

Item ID: D2572

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle, Fwd In 205

Start Date: 26/01/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 15/02/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan: M.L.JDate: 12/01/26

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2572

Rev E

100

0.00

**\*100\***

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 79421Double check by: E.K

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

110

0.00

**\*110\***

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 &amp; D2572

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 79421****\*79421\***

Page 2

January-26-12 7:43:22 AM

Item ID: D2572      Accept      \*N900040100\*      Setup Start \*NS1\*  
Revision ID:      Stop \*NS2\*  
Item Name: Saddle, Fwd In 205  
Start Date: 26/01/2012      Start Qty: 12.00      \*12\*      Cust Item ID:  
Required Date: 15/02/2012      Req'd Qty: 12.00      \*12\*      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start \*NR1\*  
QC:      Date:      SPC (Y/N):      Date:      Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|     |   |      |  |  |  |  |  |  |  |
|-----|---|------|--|--|--|--|--|--|--|
| 120 | QC2- Inspect parts off machine FAI/FAIB | 0.00 |  |  |  |  |  |  |  |
|-----|---|------|--|--|--|--|--|--|--|

**\*120\***

QC

Memo

Quality Control

|     |                                   |      |  |  |  |  |  |  |  |
|-----|-----------------------------------|------|--|--|--|--|--|--|--|
| 130 | QC8- Inspect parts - second check | 0.00 |  |  |  |  |  |  |  |
|-----|-----------------------------------|------|--|--|--|--|--|--|--|

**\*130\***

QC

Memo

Quality Control

|     |   |      |  |  |  |  |  |  |  |
|-----|---|------|--|--|--|--|--|--|--|
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 |  |  |  |  |  |  |  |
|-----|---|------|--|--|--|--|--|--|--|

**\*140\***

HandFinish

Memo

Hand Finishing

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 79421

\*79421\*

Page 3

January-26-12 7:43:22 AM

Item ID: D2572 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Saddle, Fwd In 205  
 Start Date: 26/01/2012 Start Qty: 12.00 \*12\* Cust Item ID:  
 Required Date: 15/02/2012 Req'd Qty: 12.00 \*12\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|       |  |      |  |  |  |  |  |  |  |
|-------|--|------|--|--|--|--|--|--|--|
| 150   | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 |  |  |  |  |  |  |  |
| *150* | Powdercoat                                   |      |  |  |  |  |  |  |  |
|       | Powder Coating                               |      |  |  |  |  |  |  |  |
|       | Memo   |      |  |  |  |  |  |  |  |
|       | START TIME: 7:40                             | 0.00 |  |  |  |  |  |  |  |
|       | OVEN TEMPERATURE: 320                        |      |  |  |  |  |  |  |  |
|       | FINISH TIME: 8:10                            |      |  |  |  |  |  |  |  |

8X4 M/L 12/02/08

|       |                          |      |  |  |  |  |  |  |  |
|-------|--------------------------|------|--|--|--|--|--|--|--|
| 160   | QC3- Inspect Part Finish | 0.00 |  |  |  |  |  |  |  |
| *160* | QC                       |      |  |  |  |  |  |  |  |
|       | Quality Control          |      |  |  |  |  |  |  |  |
|       | Memo                     |      |  |  |  |  |  |  |  |

8X4 M/L 12/02/08

|       |   |      |  |  |  |  |  |  |  |
|-------|---|------|--|--|--|--|--|--|--|
| 170   | Identify as per dwg & Stock Location: 432 | 0.00 |  |  |  |  |  |  |  |
| *170* | Packaging                                 |      |  |  |  |  |  |  |  |
|       | Packaging                                 |      |  |  |  |  |  |  |  |
|       | Memo                                      |      |  |  |  |  |  |  |  |

01218 SF8

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 79421****\*79421\***

Page 4

January-26-12 7:43:22 AM

Item ID: D2572

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle, Fwd In 205

Start Date: 26/01/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 15/02/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00


**\*180\***

QC

Memo

0.00

Quality Control

 M.C.J. 12/02/08M.C.J. 12/02/08  
(e)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

January-26-12 7:43:26 AM

Page 1

Work Order ID: 79421

**\*79421\***

Parent Item: D2572

**\*D2572\***

Parent Item Name: Saddle, Fwd In 205

Start Date: 26/01/2012

Required Date: 15/02/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated  
D2572KJ

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-005                       |                        | Manufactured  | No          |                     |                  | 100             | Each               | 32.0000        | 1           | 12           |               |                |        |

**\*D6101-005\***

**\*\***

Saddle Billet

Location

Loc Qty

Loc Code

MAT041

28

71721

1

→ 76838

27

MAT045

1

74507

1

MAT046

3

66966

3

8 *ank 12/02/01*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|   |                           |
|---|---------------------------|
| <b>DART AEROSPACE LTD</b>               | <b>Work Order:</b> 79421  |
| <b>Description:</b> Saddle, Fwd Inboard | <b>Part Number:</b> D2572 |
| <b>Inspection Dwg:</b> D2572 Rev. E     | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |       |       | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
|               |       |       |                | 1                          | 2     | 3     | 4     |    |      |
| A             | 0.438 | 0.443 |                | .439                       | .439  | .439  | .439  |    |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500 | 3.500 | 3.500 |    |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| E             | 7.990 | 8.010 |                | 8.001                      | 8.001 | 8.001 | 8.001 |    |      |
| F             | 0.490 | 0.510 |                | .503                       | .503  | .503  | .503  |    |      |
| G             | 0.257 | 0.262 |                | .259                       | .259  | .259  | .259  |    |      |
| H             | 0.375 | 0.380 |                | .377                       | .377  | .377  | .377  |    |      |
| I             | 0.490 | 0.510 |                | .499                       | .499  | .499  | .499  |    |      |
| J             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| K             | 0.558 | 0.578 |                | .567                       | .567  | .567  | .567  |    |      |
| L             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| M             | 1.490 | 1.500 |                | 1.495                      | 1.495 | 1.495 | 1.495 |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| O             | 3.869 | 3.879 |                | 3.873                      | 3.873 | 3.873 | 3.873 |    |      |
| P             | 0.115 | 0.135 |                | .126                       | .125  | .125  | .125  |    |      |
| Q             | 0.115 | 0.135 |                | .135                       | .135  | .135  | .135  |    |      |
| R             | 0.240 | 0.260 |                | .252                       | .251  | .251  | .251  |    |      |
| S             | 0.115 | 0.135 |                | .130                       | .128  | .128  | .128  |    |      |
| T             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |    |      |
| U             | 2.940 | 2.980 |                | 2.956                      | 2.956 | 2.956 | 2.956 |    |      |
| V             | 0.230 | 0.250 |                | .240                       | .240  | .240  | .240  |    |      |
| W             | 0.115 | 0.135 |                | .127                       | .127  | .127  | .127  |    |      |
| X             | 0.307 | 0.312 |                | .308                       | .308  | .312  | .312  |    |      |
| Y             | 0.760 | 0.765 |                | .762                       | .762  | .762  | .762  |    |      |
| Z             | 0.352 | 0.372 |                | .369                       | .369  | .369  | .369  |    |      |
| AA            | 0.470 | 0.530 |                | .500                       | .500  | .500  | .500  |    |      |
| AB            | 0.615 | 0.635 |                | .625                       | .625  | .625  | .625  |    |      |
| AC            | 0.053 | 0.073 |                | .063                       | .063  | .063  | .063  |    |      |
| AD            | 0.240 | 0.260 |                | .246                       | .247  | .247  | .247  |    |      |
| AE            | 1.375 | 1.395 |                | 1.385                      | 1.387 | 1.385 | 1.385 |    |      |
| AF            | 0.115 | 0.135 |                | .135                       | .135  | .135  | .135  |    |      |
| AG            | 0.240 | 0.280 |                | .255                       | .255  | .255  | .255  |    |      |
| AH            | 0.240 | 0.260 |                | .250                       | .250  | .250  | .250  |    |      |
| AI            | 2.000 | 2.020 |                | 2.003                      | 2.004 | 2.000 | 2.000 |    |      |
| AJ            | 0.023 | 0.043 |                | .033                       | .033  | .033  | .033  |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|                         |        |
|-------------------------|--------|
| Measured by: <i>amf</i> |        |
| Date: 12/02/01          | 12-2-2 |

|                        |  |
|------------------------|--|
| Audited by: <i>B.A</i> |  |
| Date: 12/02/07         |  |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue                               | RF         |          |
| B   | 02.09.24 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|   |  |                           |
|---|--|---------------------------|
| <b>DART AEROSPACE LTD</b>               |  | <b>Work Order:</b> 79421  |
| <b>Description:</b> Saddle, Fwd Inboard |  | <b>Part Number:</b> D2572 |
| <b>Inspection Dwg:</b> D2572 Rev. E     |  | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

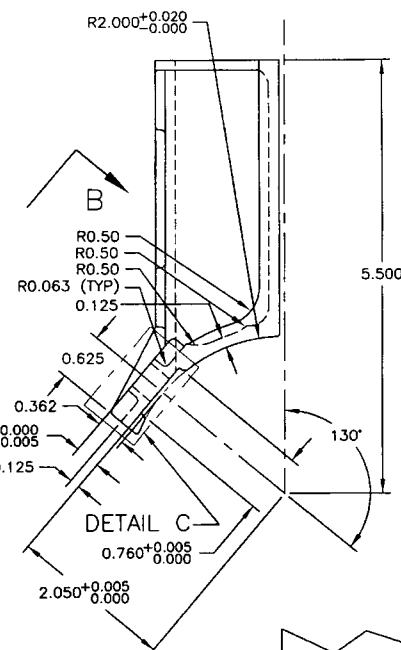
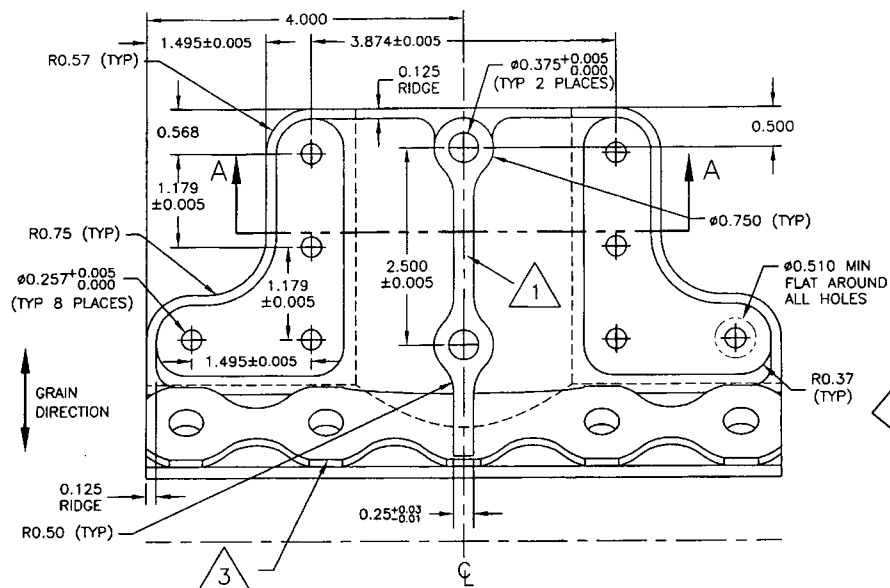
|               |       |       |                | Recorded Actual Dimensions |       |       |       |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 15                         | 16    | 17    | 18    | By | Date |
| A             | 0.438 | 0.443 |                | .439                       | .429  | .439  | .439  |    |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500 | 3.500 | 3.500 |    |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| E             | 7.990 | 8.010 |                | 8.001                      | 8.001 | 8.003 | 8.003 |    |      |
| F             | 0.490 | 0.510 |                | .503                       | .503  | .503  | .503  |    |      |
| G             | 0.257 | 0.262 |                | .259                       | .259  | .259  | .259  |    |      |
| H             | 0.375 | 0.380 |                | .377                       | .377  | .377  | .377  |    |      |
| I             | 0.490 | 0.510 |                | .499                       | .499  | .499  | .499  |    |      |
| J             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| K             | 0.558 | 0.578 |                | .567                       | .567  | .567  | .567  |    |      |
| L             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| M             | 1.490 | 1.500 |                | 1.495                      | 1.495 | 1.495 | 1.495 |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| O             | 3.869 | 3.879 |                | 3.873                      | 3.873 | 3.873 | 3.873 |    |      |
| P             | 0.115 | 0.135 |                | .126                       | .126  | .126  | .126  |    |      |
| Q             | 0.115 | 0.135 |                | .135                       | .135  | .135  | .135  |    |      |
| R             | 0.240 | 0.260 |                | .252                       | .252  | .252  | .252  |    |      |
| S             | 0.115 | 0.135 |                | .130                       | .130  | .130  | .130  |    |      |
| T             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |    |      |
| U             | 2.940 | 2.980 |                | 2.956                      | 2.956 | 2.956 | 2.956 |    |      |
| V             | 0.230 | 0.250 |                | .240                       | .240  | .240  | .240  |    |      |
| W             | 0.115 | 0.135 |                | .127                       | .127  | .127  | .127  |    |      |
| X             | 0.307 | 0.312 |                | .312                       | .312  | .312  | .312  |    |      |
| Y             | 0.760 | 0.765 |                | .763                       | .763  | .763  | .763  |    |      |
| Z             | 0.352 | 0.372 |                | .369                       | .369  | .369  | .369  |    |      |
| AA            | 0.470 | 0.530 |                | .500                       | .500  | .500  | .500  |    |      |
| AB            | 0.615 | 0.635 |                | .625                       | .625  | .625  | .625  |    |      |
| AC            | 0.053 | 0.073 |                | .063                       | .063  | .063  | .063  |    |      |
| AD            | 0.240 | 0.260 |                | .246                       | .246  | .246  | .246  |    |      |
| AE            | 1.375 | 1.395 |                | 1.385                      | 1.385 | 1.385 | 1.385 |    |      |
| AF            | 0.115 | 0.135 |                | .135                       | .135  | .135  | .135  |    |      |
| AG            | 0.240 | 0.280 |                | .255                       | .255  | .255  | .255  |    |      |
| AH            | 0.240 | 0.260 |                | .250                       | .250  | .250  | .250  |    |      |
| AI            | 2.000 | 2.020 |                | 2.003                      | 2.003 | 2.003 | 2.003 |    |      |
| AJ            | 0.023 | 0.043 |                | .033                       | .033  | .033  | .033  |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|                 |
|-----------------|
| Measured by: RF |
| Date: 12-2-3    |

|                 |
|-----------------|
| Audited by: M.A |
| Date: 12/02/07  |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue                               | RF         |          |
| B   | 02.09.24 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |

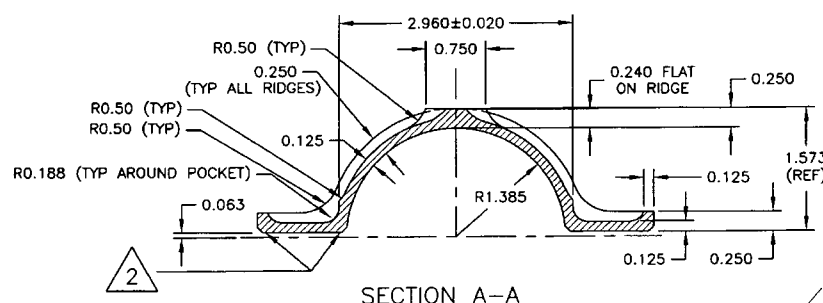
05.12.06 



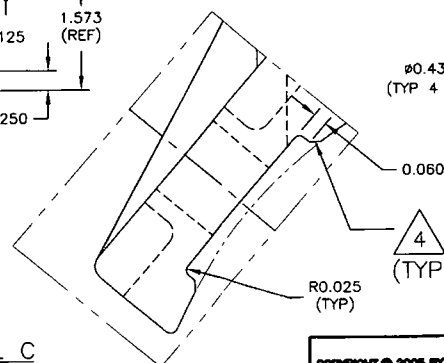
## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

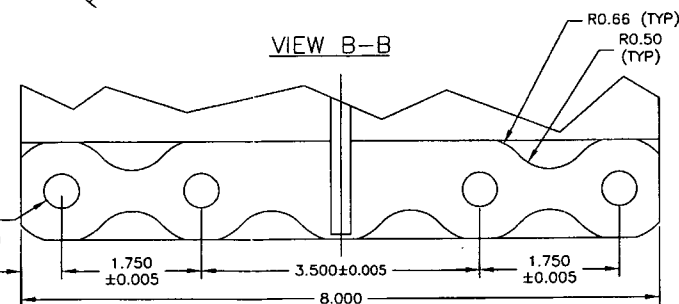
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E






SECTION A-A



DETAIL C  
SCALE 2:1



VIEW B-B

|  |   |  |  |
|--|---|--|--|
| E  | 05.07.13  | ADD CHAMFER ON RIDGE NOTE 4                                |  |
| D  | 02.09.06  | ADD CHAMFES; TIGHTEN TOLERANCES                            |  |
| C  | 99.10.22  | INCORP. DEO 9123/9079/9102<br>ADD DIMENSIONS PER TSR A1177 |  |
| B  | 96.12.02  | ADD GRAIN DIR., 0.438 WAS 0.425                            |  |
| A  | 96.09.16  | NEW ISSUE  |  |
| DESIGN<br>DS   |   | DRAWN BY<br>PH   |  <b>DART AEROSPACE LTD.</b><br>HANNESSBURY, ONTARIO, CANADA |
| CHECKED<br> | APPROVED<br> | DRAWING NO.<br>D2572                                       | REV.<br>SHEET 1 OF   |
| DATE<br>05.07.13   |   | TITLE<br>INNER FWD SADDLE                                  | SCALE<br>2:  |

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

WORK ORDER  
NO. 79421 M.C.J  
12/01/26

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DART AEROSPACE LTD.

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries